# Work Order ID 52835

*October 15, 2009 11:18:54 AM*



**Item ID:** D3929-042
**Revision ID:** A
**Item Name:** Gusset Assembly

**Start Date:** 15/10/2009 **Start Qty:** 6.00
**Required Date:** 22/10/2009 **Req'd Qty:** 6.00
**Reference:**

**Cust Item ID:**
**Customer:**

Accept

Setup Start
Stop

Run Start
Stop

**Approvals:** **Process Plan:** AA **Date:** 09-10-15 **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 100 | | 0.00 | | | | | | | |
| Waterjet | **Memo** | 0.00 | | | | | | | |
| FLOW CNC Waterjet | 1-Cut as per Dwg D3929<br>Dwg Rev: A<br>Prog Rev: A<br><br>2-Deburr if necessary | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

| Draw Nbr | Revision Nbr |
|---|---|
| D3929 | rev A |

AB 9-10-16

10

AB 9-10-16

# Work Order ID 52835



*October 15, 2009 11:18:54 AM*

**Item ID:** D3929-042 **Accept** **Setup Start** **Stop**

**Revision ID:** A

**Item Name:** Gusset Assembly

**Start Date:** 15/10/2009 **Start Qty:** 6.00 **Cust Item ID:**

**Required Date:** 22/10/2009 **Req'd Qty:** 6.00 **Customer:**

**Reference:**

**Run Start** **Stop**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 120 | QC8- Inspect parts - second check | 0.00 | | | | 10 | | | 05.10.16 |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 130 | Pick Kit | 0.00 | | | | 10x | | | SM 09/10/20 |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 140 | | 0.00 | | | | | | | |
| Large Fab | **Memo** | 0.00 | | | | | | | |
| Large Fab | Weld bushings D3907-1 as per dwg D3929 | | | | | | | | |
| | 316L rod batch: M109213 | | | | | | | | SM 09/10/20 (10x) |

# Work Order ID 52835



*October 15, 2009 11:18:54 AM*

**Item ID:** D3929-042 **Accept** **Setup Start**

**Revision ID:** A **Stop**

**Item Name:** Gusset Assembly

**Start Date:** 15/10/2009 **Start Qty:** 6.00 **Cust Item ID:**

**Required Date:** 22/10/2009 **Req'd Qty:** 6.00 **Customer:**

**Reference:**

**Run Start**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**Stop**

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 150 | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | GL | 09 | 10 | 20 |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 160 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | (10) | 0 | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 170 | Identify as per dwg & Stock Location: Basket | 0.00 | | | | (10) | | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

=> 30/10/20

PD 09.10.23

# Work Order ID 52835

*October 15, 2009 11:18:54 AM*

**Item ID:** D3929-042
**Revision ID:** A
**Item Name:** Gusset Assembly
**Start Date:** 15/10/2009 **Start Qty:** 6.00
**Required Date:** 22/10/2009 **Req'd Qty:** 6.00
**Reference:**

**Accept** **Setup Start** **Stop**

**Cust Item ID:**
**Customer:**

**Run Start** **Stop**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

09.10.27

BL 09-10-23

# Picklist Print



*October 15, 2009 11:19:01 AM*

**Work Order ID:** 52835

**Parent Item:** D3929-042RevA

**Parent Item Name:** Gusset Assembly

**Comments:**

**Start Date:** 15/10/2009 **Required Date:** 22/10/2009

**Start Qty:** 6.00 **Required Qty:** 6.00

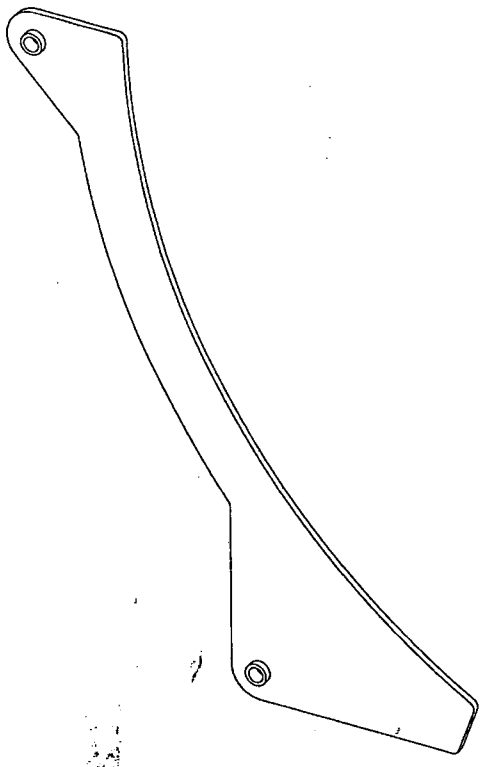
| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| M304S11GA | | Purchased | No | | | 100 | sf | 157.7312 | 2.8421 | 5.684 | 9-10-16 | |
| 304/316 0.125 Sheet | | | | | | | | | | | | |

| Warehouse Location | Loc Qty | Loc Code | | |
|---|---|---|---|---|
| Main Warehouse | | | | |
| MAT | 157.7311979 | | | |
| 111018 | 29.7311979 | | | 111018 |
| 112663 | 128 | | | |

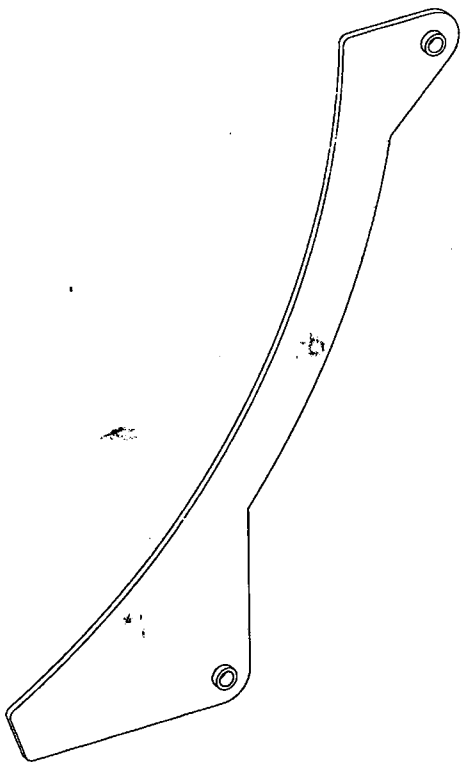
| | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| D3907-1RevA | | Manufactured | No | | | 130 | Each | 44.0000 | 12.0000 | | | |
| Bushing | | | | | | | | | | | | |

| Warehouse Location | Loc Qty | Loc Code | | |
|---|---|---|---|---|
| Main Warehouse | | | | |
| ST | 44 | (17+4) | | |
| 50944 | 4 | | 17 x | |
| 51475 | 40 | | 3x | 09/10/20 B |

| ITEM | QTY -041 | QTY -042 | P/N | DESCRIPTION |
|---|---|---|---|---|
| 1 | X | | D3929-041 | GUSSET ASSEMBLY |
| 2 | | X | D3929-042 | GUSSET ASSEMBLY |
| | | | | |
| 11 | 2 | 2 | D3907-1 | BUSHING |
| 12 | 1 | 1 | D3929-1 | SUPPORT GUSSET |



**D3929-041 GUSSET ASSEMBLY**



**D3929-042 GUSSET ASSEMBLY**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 528355
09-10-15

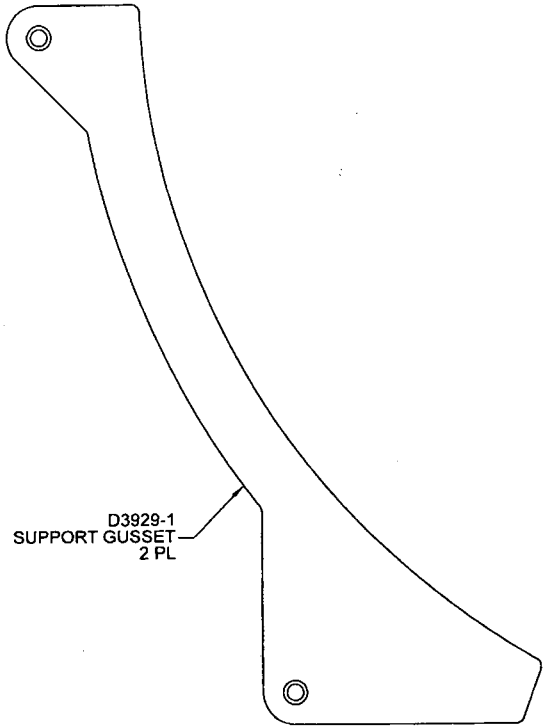
RELEASED
9/04/12 NM

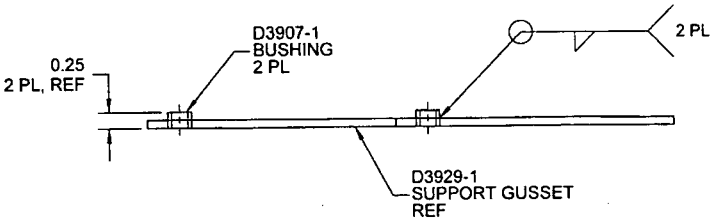
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 lbs EACH
8) WELDING: PER DART QSI 004

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| A | NEW ISSUE | MB | 09.04.03 |

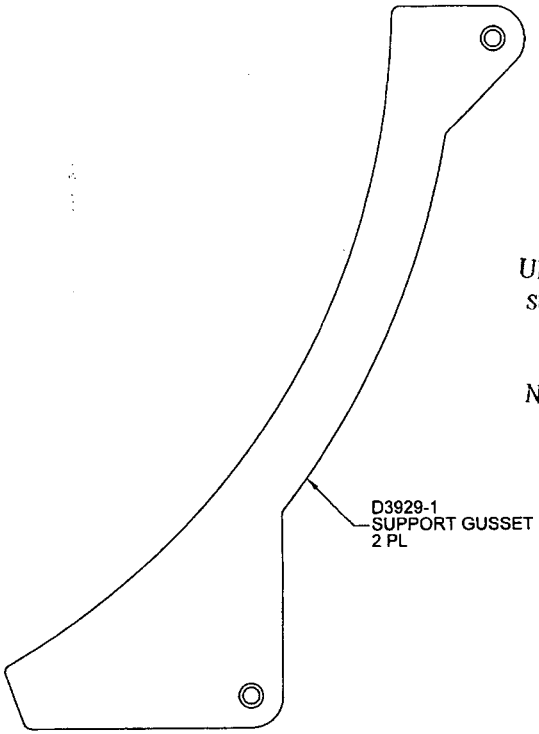
| | | |
|---|---|---|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | PK | DRAWING NO. D3929 REV. A |
| MFG. APPR. | | SHEET 1 OF 3 |
| APPROVED | | TITLE GUSSET ASSEMBLY SCALE NTS |
| DE APPR. | | |
| DATE | 09.04.03 | |

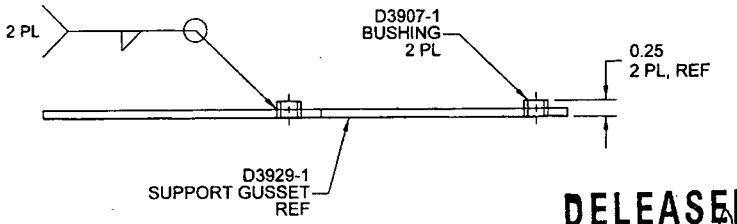
COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.




**D3929-041 GUSSET ASSEMBLY**



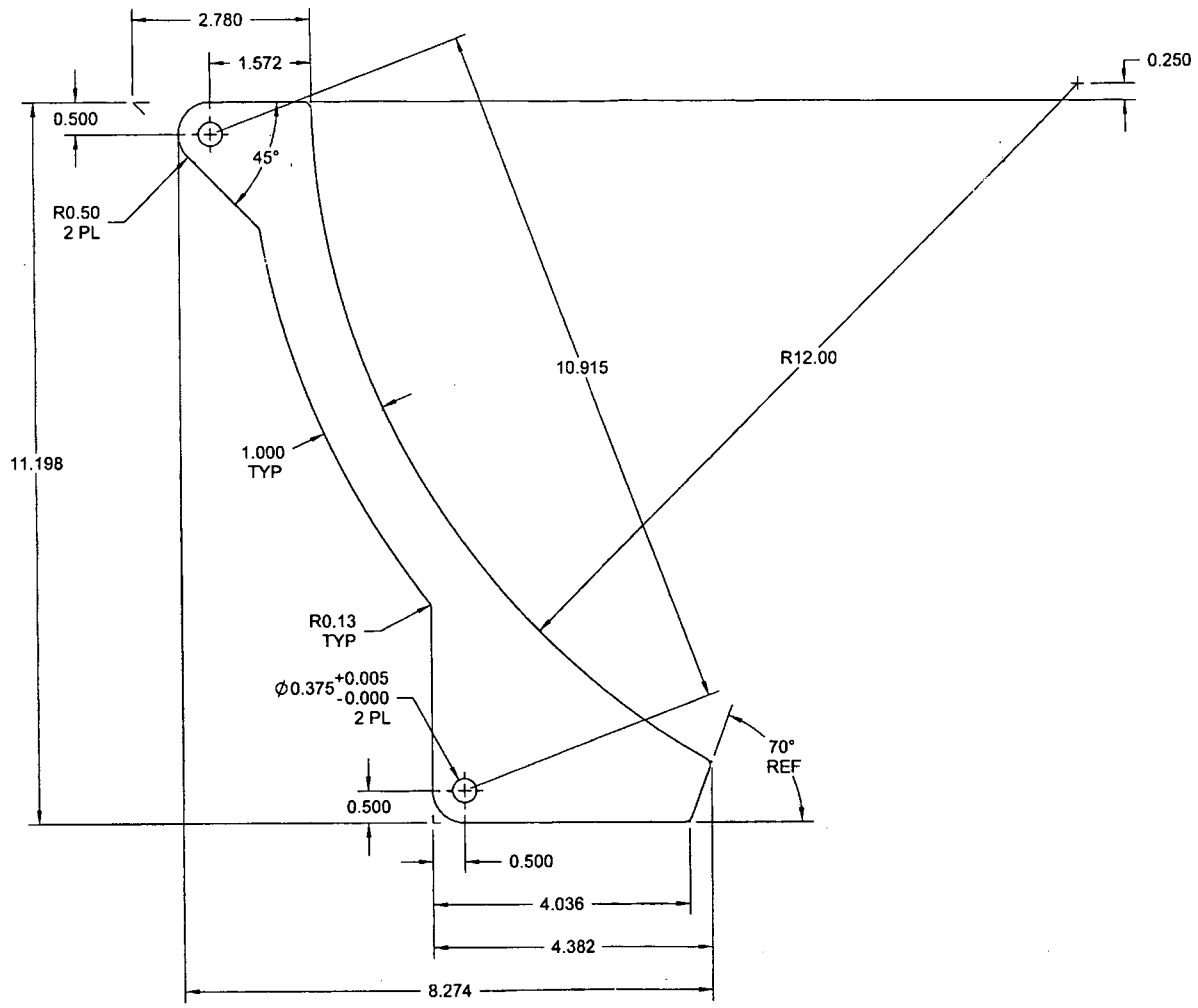

**D3929-042 GUSSET ASSEMBLY**

SHOP
REF
ENGI
UNCONTE
SUBJECT TO
WITH
WOR
NO. 52835

RELEASED
29/04/22 MD

| | | |
|---|---|---|
| DESIGN | | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| DRAWN | | |
| CHECKED | | DRAWING NO. D3929 REV. A |
| MFG. APPR. | | SHEET 2 OF 3 |
| APPROVED | | TITLE GUSSET ASSEMBLY SCALE NTS |
| DE APPR. | | |
| DATE 09.04.03 | | |

COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD




**D3929-1 SUPPORT GUSSET**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52835

RELEASED
9/04/22 MD

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
5) IDENTIFICATION: N/A
7) WEIGHT: 0.72 lbs

| | | |
|---|---|---|
| DESIGN | | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | | |
| CHECKED | PB | DRAWING NO. D3929 REV. A |
| MFG. APPR. | | SHEET 3 OF 3 |
| APPROVED | | TITLE GUSSET ASSEMBLY SCALE NTS |
| DE APPR. | | |
| DATE 09.04.03 | | |

COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

| DART AEROSPACE LTD | Work Order: | 52835 |
|---|---|---|
| | | |
| **Description:** Support Gusset | Part Number: | D3929-1 |
| | | |
| **Inspection Dwg:** D3929 **Rev:** A | | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| Ø0.375 | +0.006/-0.001 | .378 | X | | | |
| 0.500 | +/-0.010 | .500 | X | | | |
| 0.500 | +/-0.010 | .500 | X | | | |
| 4.036 | +/-0.010 | 4.037 | X | | | |
| 4.382 | +/-0.010 | 4.379 | X | | | |
| 8.274 | +/-0.010 | 8.275 | X | | | |
| 10.915 | +/-0.010 | 10.917 | X | | | |
| 1.000 | +/-0.010 | 1.009 | X | | | |
| 11.198 | +/-0.010 | 11.191 | X | | | |
| 0.500 | +/-0.010 | .499 | X | | | |
| 1.572 | +/-0.010 | 1.574 | X | | | |
| 0.125 | +/-0.010 | .119 | X | | | |

| Measured by: | [redacted] |
|---|---|
| Date: | 9-10-16 |

| Audited by: | |
|---|---|
| Date: | 05.16.16 |

| Prototype Approval: | N/A |
|---|---|
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | 09.05.27 | New Issue P/O D3929-041/-042 | KJ | |

H:\FORMS\Quality Assurance\approved QA\FAI revD